



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3699-042
Job Sheet 178607



Part No: D3699-042

Job Qty: 5 ea

Part Name: Support Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/4/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 08-04-25 new issue DD verified by:ec IPP Rev:B 08-07-14 revA as per dwg DD
verified by:ec IPP REV:C 17.12.05 ADD MISSING INFO THAT WAS IN INTUITIVE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Waterjet		SA 18-06-05
100	Waterjet	5 pcs	6/8/18	6/8/18	0.00	0.87	Waterjet1		SA 18-06-05
110	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Waterjet-2		SA 18-06-05
120	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC8-3		SA 18-06-05
150	Small Fab	5 pcs	6/8/18	6/8/18	0.00	0.13	Small Fab-4		SA 18-06-05
160	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC5		SA 18-06-05
170	HandFinish	5 pcs	6/8/18	6/8/18	0.00	0.29	HandFinish1		SA 18-06-05
180	Powdercoat	5 pcs	6/8/18	6/8/18	0.00	0.37	Powdercoat4		SA 18-06-05
190	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC3		SA 18-06-05
200	Packaging	5 pcs	6/8/18	6/8/18	0.00	0.00	Packaging1-4		SA 18-06-05
210	Small Fab	5 pcs	6/8/18	6/8/18	0.00	0.13	Small Fab-4		SA 18-06-05
220	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC5		SA 18-06-05
230	Packaging	5 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-1		SA 18-06-05
240	QC21-SA	5 Ea	6/8/18	6/8/18	0.00	0.00	QC21		SA 18-06-05

Part Op 100 - 1-Cut as per Dwg D3699 Dwg Rev: A Prog Rev: A ***grain direction along 9.00" *** 2- Debur

Descriptions: necessary

150 - 1-Counter sink holes and deburr as per dwg D3699 2- Bend as per dwg

180 - START TIME: 3:20 OVEN TEMPERATURE: 300 FINISH TIME: 3:50

210 - Assemble as per dwg D3699

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.050	6061-T6 .050 Sheet	2.2845 sf (.4569 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	10 Ea (2 ea)	210-Small Fab	5018535
MS21059L3	Nut Plate	5 Ea (1 ea)	210-Small Fab	5025740

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.050	2	104	0
210-Small Fab	MS20426AD3-3	10	4,478	0
	MS21059L3	5	145	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unappr ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; text-align: center;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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Part Specifications

Specifications could not be found.

Plex 6/4/18 2:25 PM Dart.lajeunesse.marie

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WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order: 178607
Description: Support, RH		Part Number: D3699-2
Inspection Dwg: D3699	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.099	1		VSC-01	
Ø0.180	+0.005/-0.001	Ø0.182	1			
Ø0.238	+0.005/-0.001	Ø0.241	1			
Ø1.525	+0.012/-0.001	Ø1.526	1			
0.36	+/-0.030	0.362	1			
0.62	+/-0.030	0.623	1			
0.96	+/-0.030	0.965	1			
2.21	+/-0.030	2.213	1			
4.12	+/-0.030	4.127	1			
8.95	+/-0.030	8.956	1			
1.925	+/-0.010	1.927	1			
8.61	+/-0.030	8.617	1			
2.62	+/-0.030	2.622	1			
0.344	+/-0.010	0.345	1			
0.688	+/-0.010	0.690	1			
0.64	+/-0.030	0.641	1			
2.66	+/-0.030	2.663	1			
5.75	+/-0.030	5.754	1			
6.41	+/-0.030	6.415	1			
0.300	+/-0.010	0.301	1			
0.923	+/-0.010	0.925	1			
0.050	+/-0.010	0.048	1			

Measured by: SC	Audited by: RP	Prototype Approval:	N/A
Date: 18/06/05	Date: JUN 05 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	

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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								